Each

Friday, 9/14/2007 2:00:51 PM

Kim Johnston User:

**Process Sheet** 

**Drawing Name** 

**Part Number** 

Material

**Due Date** 

**Drawing Number** 

Project Number

**Drawing Revision** 

: LUG

: D22493

: N/A

D2249 REV. E

: 10/20/2007

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

**Estimate Number** 

: 34671B : 10841

P.O. Number

This Issue

Prsht Rev.

First Issue

Written By

Previous Run

: 9/14/2007

: NC

S.O. No. : 1

: MA : 31609B

: SMALL /MED FAB

Checked & Approved By

Comment

Added Step 9 KJ/RF : Est: D 05.62.04

Now On Waterjet 07-03-08 JLM Est Rev:E

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

304/316 .063 Sheet

1.0

M304S16GA

Comment: Qtv.: 0.1470 sf(s)/Unit Total: 304/316 .063 Sheet

Batch: WIOI 873

1.4700 sf(s)

2.0

WATER JET



FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D2249

Dwg Rev: Prog Rev:\_\_\_

B 67-09-19

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SMALL FAB



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D2249

Page 1

## Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1						
Part No	) <b>:</b>	PAR	#: Fault Category:	NCR	Yes	No DQ	A: <u>Д</u>	Date: Ø	769/3 <del>3</del>

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

WORK ORDER NON-CONFORMANCE (NCR)							
	Description of NC		Corrective Action Section B		Varification		A
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC inspector
		į					
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Initial Action Description Sign & Section C Chief Eng

NOTE: Date & initial all entries

Friday, 9/14/2007 2:00:51 PM Date: User: Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: LUG Job Number: 34671B Part Number: D22493 Job Number: Seq. #: Machine Or Operation: Description: INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 PACKAGING RESOURCE #1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 -1109, U Sqc09.28 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Ae	rospace	Ltd	•							
W/O:			٧	VORK ORDER C	CHANGES					<del> </del>
DATE	STEP	EP PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
					-					
Part No	:	PAR #:	Fault Ca	tegory:	NC	R: Yes N	lo DQA	:	Date:	
						QA: N/C	C Closed:	:	_ Date: _	
NCR:			WORK OR	DER NON-CONI	FORMANCE	(NCR)				
	T	Description of NC		Corrective Action	Section B		Verifica	ation	Approval	Annroval
DATE	STEP	Section A	Initial Chief Eng	Action Desc Chief En		Sign & Date	Section		Chief Eng	Approval QC Inspector
								1		

	WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC Corrective Action Section B				Verification	Approval	Approval		
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto		
					,				
			1994 1994 1944 1944 1944 1944 1944 1944				· · ·		
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Verification Section C	STEP Description of NC Section A Proval Initial Action Description Sign & Chief Eng		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	346713
Description: Base Plate	Part Number:	D2249-3
Inspection Dwg: D2249 Rev: E		Page 1 of 1

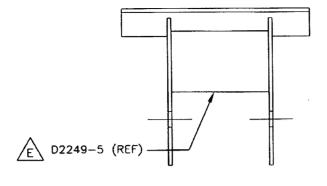
	FIRST	ARTICLE II	NSPECTI	ON CHE	CKLIST		
	X	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comr	nents
Ø0.261	+0.006/-0.001	,264	*				
4.44	+/-0.030	4446	*				
3.690	+/-0.010	3,690	×				
2.400	+/-0.010	2.40	*				
3.20	+/-0.030	3,20	*				
0.375	+/-0.010	,375	*				
0.400	+/-0.010	,400	×		1//		
			<u> </u>				· · · · · · · · · · · · · · · · · · ·
			:				
Measured by:	В	Audited by:	\(\frac{1}{2}\)		Prototype Ap	proval:	N/A
	57-09-19	Date:	Mall	80		Date:	N/A

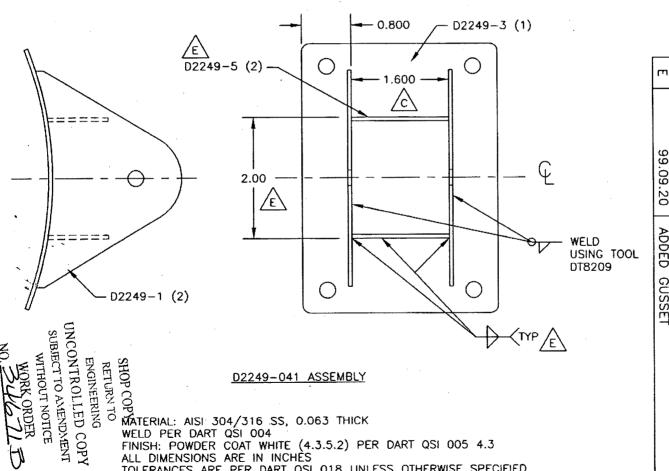
Rev	Date	Change	Revised by	Approved
Α	07.03.23	New Issue	KJ/JLM	
			7 (1)	7,007

99.10.12 



ON CO
(Sales)





D2249-041 ASSEMBLY

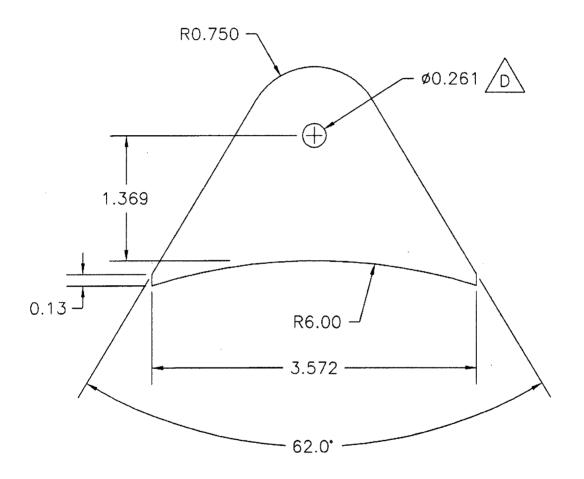
MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED





DESIGN	DRAWN BY	<b>—</b> • • • • • • • • • • • • • • • • • • •	AEROSPACE LTD ESBURY, ONTARIO, CANADA	<del></del>
CHECKED	APPROYED	DRAWING NO.	REV.	Ε
#E	<del>       </del>	D2249	SHEET 2 OF	4
DATE		TITLE	SCA	LE.
99.09.20		FITTING		1:1





D2249-1 LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

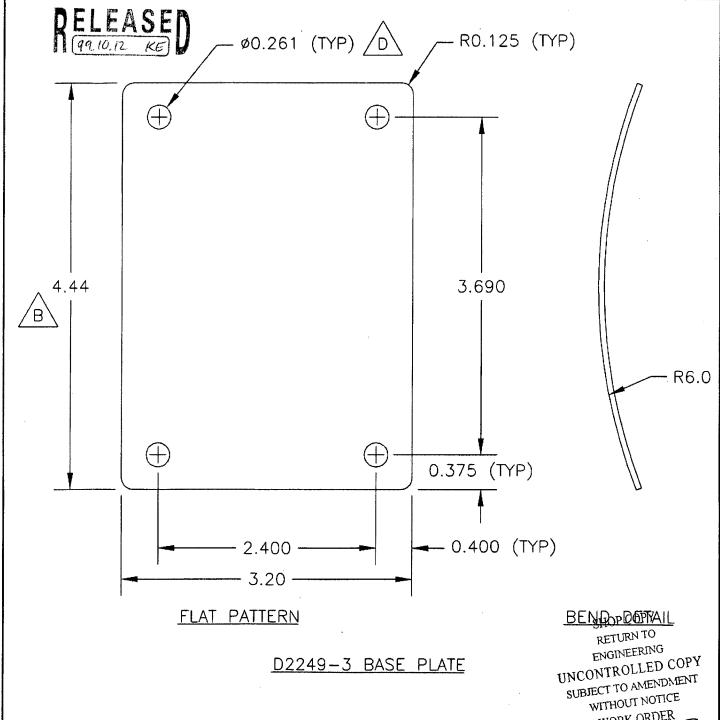
MATERIAL: AISI 304/316 SS 0.063 THICK ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





DESIGN	DRAWN BY		ROSPACE LTD y, ontario, canada	<del></del>	
CHECKED	APPROYED	DRAWING NO.		REV.	E
ME	#	D2249	SHEET	3 OF	4
DATE		TITLE		SCA	LE
99.09.20		FITTING			1:1



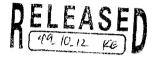
MATERIAL: AISI 304/316 SS 0.063 THICK ALL DIMENSIONS ARE IN INCHES TO FRANCES ARE PER DART OSL 018 UNI

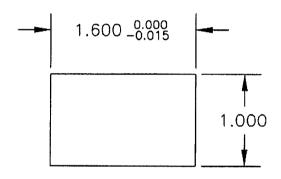
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





)	DESIGN	DRAWN BY	DART AEROS HAWKESBURY, ONTA	
,	CHECKED	APPROVED	DRAWING NO. D2249	REV. E SHEET 4 OF 4
	DATE	······································	TITLE	SCALE
	99.09.20		FITTING	1:1





D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE IN TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTE IN THE DESCRIPTION OF THE PER DART QSI 018 UNLESS OTHERWISE NOTE IN THE DESCRIPTION OF THE PER DART QSI 018 UNLESS OTHERWISE NOTE IN THE DESCRIPTION OF THE PER DART QSI 018 UNLESS OTHERWISE NOTE IN THE DESCRIPTION OF THE PER DART QSI 018 UNLESS OTHERWISE NOTE IN THE DESCRIPTION OF THE PER DART QSI 018 UNLESS OTHERWISE NOTE IN THE DESCRIPTION OF THE PER DART QSI 018 UNLESS OTHERWISE NOTE IN THE DESCRIPTION OF THE PER DART QSI 018 UNLESS OTHERWISE NOTE IN THE DESCRIPTION OF THE PER DART QSI 018 UNLESS OTHERWISE NOTE IN THE DESCRIPTION OF THE PER DART QSI 018 UNLESS OTHERWISE NOTE IN THE DESCRIPTION OF THE PER DART QSI 018 UNLESS OTHERWISE NOTE IN THE DESCRIPTION OF THE PER DART QSI 018 UNLESS OTHERWISE NOTE IN THE DESCRIPTION OF THE PER DART QSI 018 UNLESS OTHERWISE NOTE IN THE DESCRIPTION OF THE PER DART QSI 018 UNLESS OTHERWISE NOTE IN THE DESCRIPTION OF THE PER DART QSI 018 UNLESS OTHERWISE NOTE IN THE DESCRIPTION OF THE DESCRIPTION

SHOP COPY

PETURN TO

NO THE COPY

UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER